

Work Order ID 70020

Wednesday, May 25, 2011 12:03:41 PM



Page 1

Item ID: D3022-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Pan

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/05/25 Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3022

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3022

Dwg Rev: BProg Rev: B

*** grind direction along 31.700" ***

2-Deburr if necessary

B 11-5-30

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-5-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S 5/25/11



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

S 5/25/11



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1- Bend as per Dwg D3022

140

QC5- Inspect part completeness to step on W/O

0.00

S 5/25/11



QC

Memo

0.00

Quality Control

(FL)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Transfer drill Seat Pan From Frame
Transfer drill in D3022-1 using D3017-041

2-Deburr

EL 11-6-73 (X1)

160

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S uloc 14

170

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

1 0 uloc 14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating <i>M115128</i>	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <i>8:30</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>9:00</i>	0.00 0.00 <i>0.00</i>							<i>IX</i> <i>✓</i> <i>M-11/06/14</i>
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>1</i> <i>BR 11-6-14</i>
200 Packaging Packaging	Identify as per dwg & Stock Location: <i>G-A</i> Memo <i>w/o</i> <i>70006</i>	0.00 0.00							<i>ES</i> <i>11/06/14</i> <i>①</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/14
MF
11-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 12:03:39 PM

Page 1

Work Order ID: 70020



Parent Item: D3022-1



Parent Item Name: Seat Pan

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C 02.01.23 Revised NG

IPP Rev:D 08-04-16 now water jet DD verified by:EC

IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

39.9000

1.6232

1.708632



1B11-5-32

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT22

39.9

111699

0.5

113189

39.4

113189

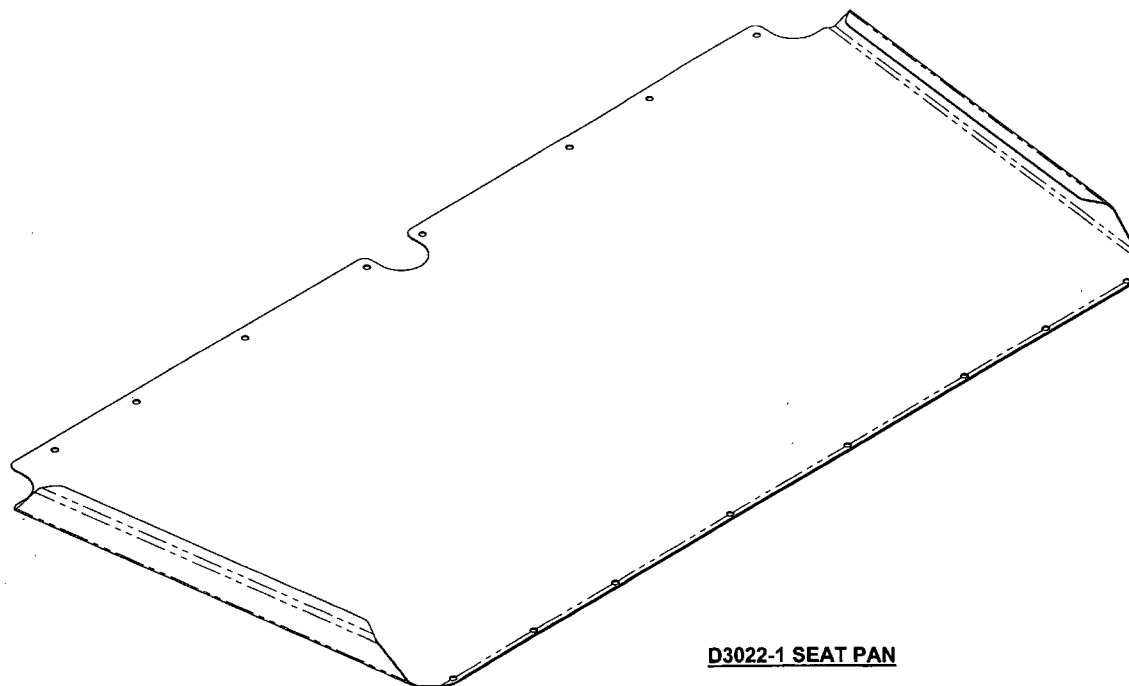
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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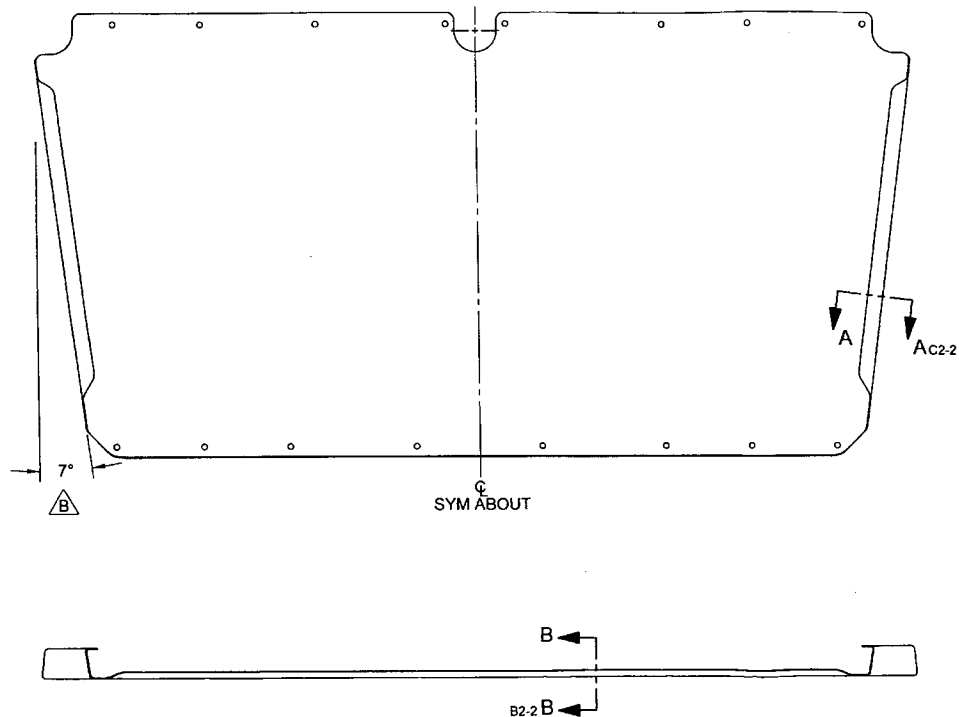


D3022-1 SEAT PAN

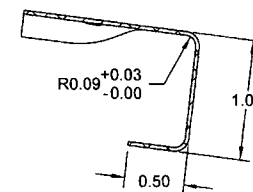
CL11105125
W/O: 70020

RELEASED
08/12/15 NIP

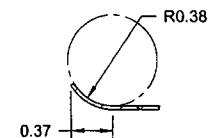
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2 7" DIM ADDED, D7-3 12.075 WAS 12.325, D8-3 9.175 WAS 9.425 & D9-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.		AJS	08.11.27
A	NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3022	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SEAT PAN	NTS	
DATE	08.11.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		



D3022-1 SEAT PAN



SECTION A-A C4-2
SCALE 4X



SECTION B-B A6-2
SCALE 4X

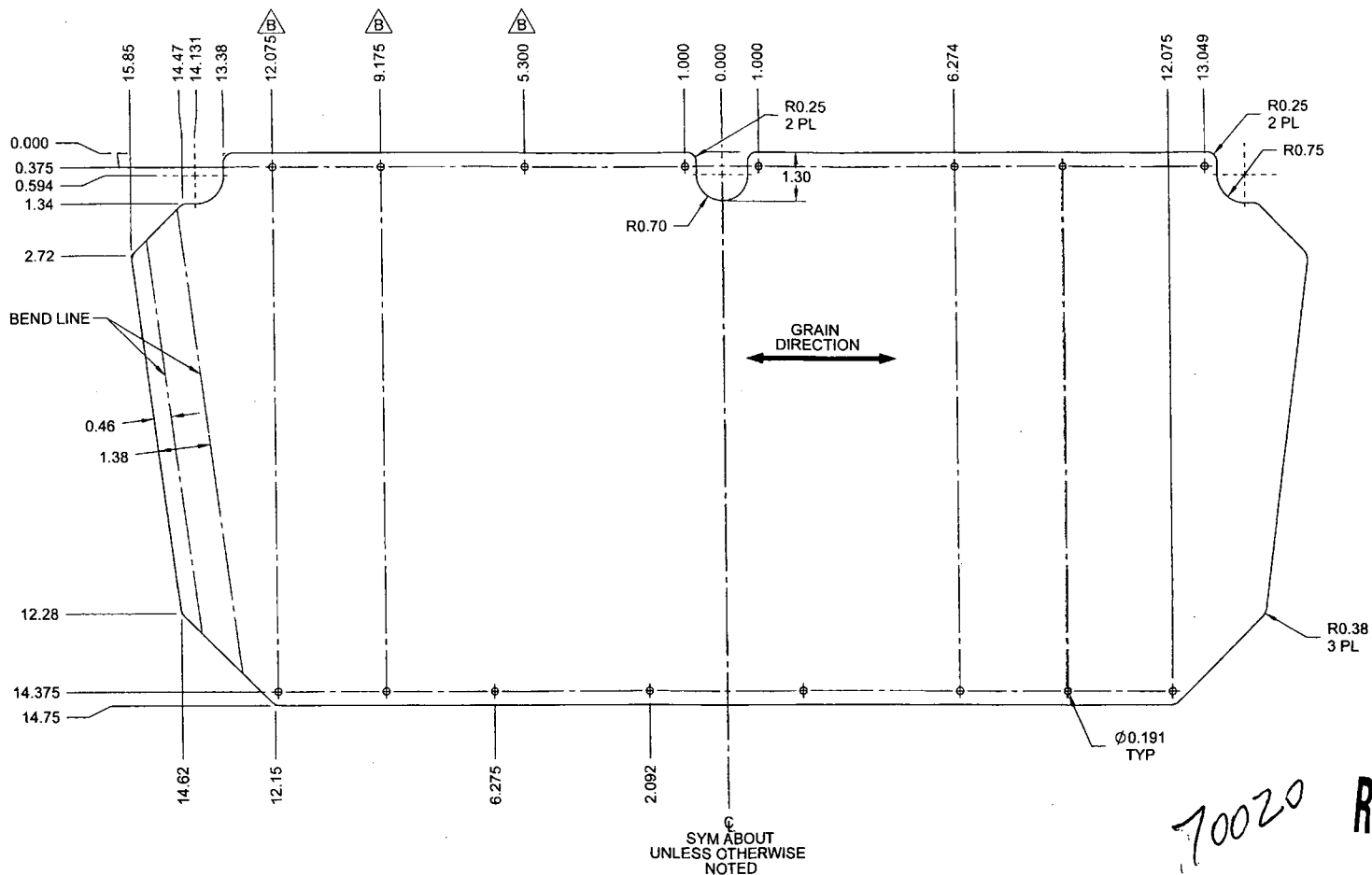
70020

RELEASED
08/12/5

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
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